

Work Order ID 142870

Friday, April 22, 2016 12:35:26 PM

142870

Page 1

Item ID: D205-564-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bell Medium Bearpaws

Start Date: 4/27/2016 Start Qty: 8.00

Q

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 8100

Q

Customer:

Reference:

Approvals: Process Plan: MLJ Date: APR 22 2016 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D205-564	H

DAS
6
2-89

MLJ 16-05-04

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy blue file and type labels per PPP D205-564-011 CHG009							

TX DAS
27
2-89
MAY 04 2016

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

7 31
DAS 28
6 1-89
APR 25 2016

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.24							
Quality Control									

TX DAS
27
9-89

MAY 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval 																		
Description Work Order Deviation				Disposition																					
							Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 142870

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142870

Page 2

Item ID: D205-564-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bell Medium Bearpaws

Stop ***NS2***

Start Date: 4/27/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-564-011
LOCATION: FG015

Packaging

7X

BAS
27
9.50

MAY 04 2016

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.80

Quality Control

MLJ

MAY 04 2016

20160502
Jat

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☒	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

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Page 1

Work Order ID: 142870

142870

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 4/27/2016

Required Date: 5/9/2016

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP F00.01.20 Changed pick list, MPP 2019, CHG006EC
 IPP Rev:G 06-08-28 As per Rev E JLM
 IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC
 IPP Rev:I 08-10-01 New Manufacturing Method JLM Verf By:EC IPP
 REV:J 15.06.05 as per ecn15-574/chg009 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2274

Manufactured

No

110

Each

113.0000

20

140

D2274

Radius Block

** 43 X(44391

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

101

141052

101

97

D2521

Manufactured

No

110

Each

0.0000

2

14

D2521

Individual Bearpaw

** 142767

DAS 28 9-89

D2529

Manufactured

No

110

Each

628.0000

20

150

D2529

Washer

** -

DAS 28 9-89

Location

Loc Qty

Loc Code

ST008

500

143819

500

ST009

128

141458

128

27

133

APR 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 142870

142870

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 4/27/2016

Required Date: 5/9/2016

Start Qty: 8.00

Required Qty: 8.00

D3544-041

Manufactured No

110

Each

16.0000

4

D3544-041

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST542

16

142569

16

D4060-1

Manufactured No

110

Each

15.0000

8

D4060-1

Ski Clamp, Top

DAS
27
9-89

Location

Loc Qty

Loc Code

ST542

15

142759

15

D4061-1

Manufactured No

110

Each

25.0000

8

D4061-1

Ski Cushion

DAS
27
9-89

Location

Loc Qty

Loc Code

ST544

25

142483

25

AN4-13A

Purchased No

110

Each

327.0000

8

AN4-13A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

37

m134167

37

ST344

270

m134260

9

m134497

261

**

**

**

**

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89
APR 25 2016

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Shop Packet Print

Page 2



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:			QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation					Disposition					
										Completed By
										Lead hand / Supervisor Approval Verification
										QC / QA Coordinator Approval
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due			FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
OTHER :										

Picklist Print

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Work Order ID: 142870

142870

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 4/27/2016

Required Date: 5/9/2016

Start Qty: 8.00

Required Qty: 8.00

AN4-15A Purchased No 110 Each 296.0000 20 ******

AN4-15A
Bolt

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	34	
120449	34	
ST343	262	
m134606	262	

NAS1149D0463J Purchased No 110 Each 2,824.000 20 ******

NAS1149D0463.J
WASHER

DAS
27
9-89

DAS
28
9-89
APR 25 2016

Location	Loc Qty	Loc Code
GA	342	
M132035	21	
M134508	321	
ST260a	600	
M134508	600	
ST263	894	
M134039	29	
M134573	865	
ST269	988	
M132317	100	
M132677	888	

Picklist Print

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Work Order ID: 142870

142870

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 4/27/2016

Required Date: 5/9/2016

Start Qty: 8.00

Required Qty: 8.00

MS21042L4

Purchased

No

110

Each

2,054.000

20

160

MS21042L4

Locknut

Location

Loc Qty

Loc Code

GA

288

m133769

288

OVER007

1500

m134509

500

m134606

1000

ST303

169

m134055

1

m134502

168

ST305

97

m130922

97

DAS
27
9-89

DAS
6
9-89

APR 25 2016
DAS
28
9-89

~~160~~ 131 -*

5.0 PARTS LIST

Qty /-011	Qty -013	Qty -015	Part Number	Description
X			D205-564-011	BEARPAW INSTALLATION
	X		D205-564-013	BEARPAW SKI INSTALLATION
		X	D205-564-015	SKI UPGRADE KIT
20	52	32	D2274	RADIUS BLOCK
2	2		D2521	BEARPAW
20	12	12	D2529	WASHER
4			D3544-041	CLAMP
	2	2	D3795-1	FWD SKI SECTION
	2	2	D3795-3	MID SKI SECTION
	2	2	D3796-041	WEARPLATE
	2	2	D3796-043	WEARPLATE
8	26	18	D4060-1	CLAMP (REPLACES D2947)
8	26	18	D4061-1	CUSHION (REPLACES D2182B055)
	8	8	AN4-12A	BOLT
8			AN4-13A	BOLT
20			AN4-15A	BOLT
	52	52	AN4-20A	BOLT
20	52	32	AN960JD416	WASHERS (OR NAS1149D0463J)
	8	8	AN970-4	WASHER
20	60	40	MS21042L4	NUT (OR MS21042-4)

Qty	Part Number	Description
X	DSI 9328-011	RUN-ON LANDING WEARPLATE KIT
2	D3511-041	WEARPLATE
16	AN4-20A	BOLT
4	AN4-12A	BOLT
4	AN970-4	WASHER
16	MS21042L4	NUT (OR MS21042-4)

56
25